Work Orde Tuesday, March							,					Page 1
Revision ID:	D3479-041 Inlet Adapter			Accept					Setup	Start Stop		
Start Date: Required Date: Reference:	3/1/2011 3/7/2011	Start Qty: 2.00 Req'd Qty: 2.00			Cust Item I Customer:	D:						
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ite:		.]	Run	Start Stop		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty_	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr							1			
D3479	Rev	В						(マロ)			
Small Fab		Small Fab Memo 1-Assemble 2-Spot Web	e as per Dwg D3479 d as per Dwg D3479 and Da	0.00 0.00 rt QSI 018	ml	n/o:	3/14	+				
QC Quality Control		QC11- Inspect spot wel	d per QSI004	0.00	is ulogia		ı	<u></u>				
120		QC5- Inspect part comp	oleteness to step on W/O	0.00	A 11/03/14			D				

0.00

Memo

Quality Control

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	RES				
DATE	STEP	PROC	EDURE CHAN	IGE	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					i i				
	<u> </u>								
Part No	:	PAR #:	_ Fault Categ	jory:	NCR: Ye	s No	DQA:	Date: _	
	Res	solution:	_ Disposition	:	QA: N/C	Closed:		Date: _	
NCR:		W	ORK ORDE	R NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC		tion B	Ve	rification	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig: Da		Section C	Chief Eng	QC Inspector
			46,						
		•						i i	

Work Order ID 66856

Tuesday, March 01, 2011 8:04:24 AM



Page 2

Item ID:

D3479-041

Accept

Setup Start

Stop



Item Name: **Start Date:**

Revision ID:

Inlet Adapter 3/1/2011

Start Qty: 2.00

Required Date: 3/7/2011

Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Reject

Sequence ID/ Work Center ID

130

Packaging

Operation Description

Identify as per dwg & Stock Location:

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty_

Insp. Number

Stamp

Packaging

Memo

PM 66 CF2 0.00

0.00

QC

Quality Control

140

Memo

0.00

me 11-03-14

Dart Aero:	space	Ltd
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Dan Aei	ospace	: Lta							· •
W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	jory: !	NCR: Yes	No DQ	A:	Date:	
-	R	esolution:	Disposition):(A: N/C CI	osed:		Date: _	
NCR:		\	WORK ORDE	R NON-CONFORMAN	CE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section E Action Description Chief Eng	Sign &			Approval Chief Eng	Approval QC Inspector
									:

Picklist Print

Tuesday, March 01, 2011 8:04:30 AM

Work Order ID: 66856

Parent Item:

D3479-041

Parent Item Name: Inlet Adapter



Start Date: 3/1/2011

Required Date: 3/7/2011

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

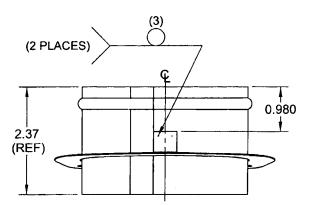
IPP Rev: A New Issue 06-02-02 JLM

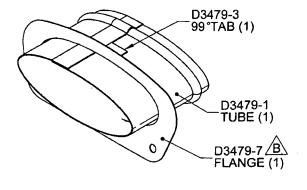
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3479-1		Manufactured	No			100	Each	0.0000	1	2 M	1-1	11/0	4u
D3479-3		Manufactured	No			100	Each	3.0000		2 	7-A	11/0	5/81/
					35162 46274	<u>Loc (</u>		Loc Code e7 (39	_ _	1	,	`.	•
D3479-5 Tab, 81 degrees		Manufactured	No			100	Each	2.0000		2 M	1	11/0	3/42
				Location ST064	35163	<u>Loc (</u>	$\frac{\text{Otv}}{2} \mathcal{B}$	Loc Code 67191	· _	2_	-		
D3479-7		Manufactured	No			100	Each	2.0000	1	2 M/		11/0	3/11
				Location ST064	34090	Loc	2 2	Loc Code		a x	- -	·	

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DATE	STEP	P	ROCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:						
	Re	esolution:	Disposition	n:	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC			tion B	Verification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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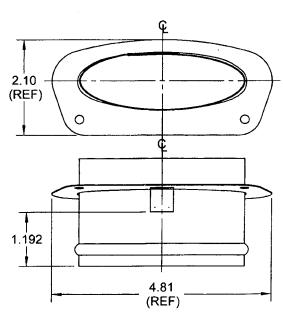


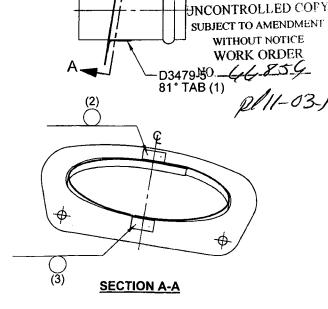
	L	1		
DESIGN		DRAWNBY	DART AEROSPACE HAWKESBURY, ONTARIO	
CHECK		APPROVED	DRAWING NO.	REV. B
<i>Pe</i>	/	M	D3479	SHEET 1 OF 4
DATE			TITLE	SCALE
	08.1	12.19	INLET ADAPTER	1:2
Α	0	6.01.19	NEW ISSUE	
В	0	8.12.19	CORRECT TYPO ON SHT1; AD	D TOL ON SHT2;





SHOP COPY RETURN TO **ENGINEERING**





D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018
- FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING
- FINE POINT PERMANENT INK MARKER
 4) TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
Х	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

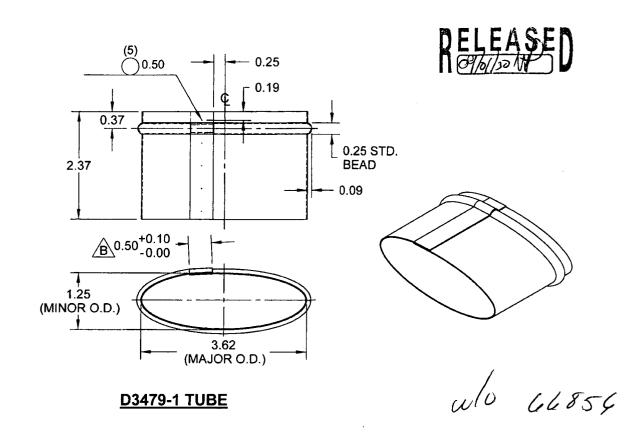
COPYRIGHT © 2006 BY DART AEROSPACE LTD.

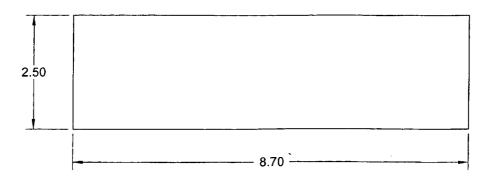
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W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: `	Yes N	o DQ	A:	Date:	
		esolution:								
NCR:			WORK ORD	ER NON-CONFORM	IANCE (N	VCR)				
DATE	OTED	Description of NC			ction B		Verific	cation	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section C			QC Inspector
										!
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DESIGN	DRAWN BY	DART AEROS HAWKESBURY, O	
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 2 OF 4
DATE	12.19	INLET ADAPTER	SCALE 1:2





D3479-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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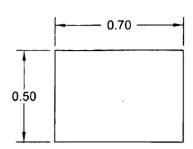
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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	1:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR	3)			
DATE	STEP	Description of NC	Corrective Action				cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Sect	tion C	Chief Eng	QC Inspector
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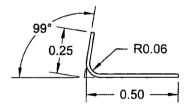
DESIGN	DRAV N BY	DART AERO HAWKESBURY, O	
CHECKED	APPROVED	DRAWING NO.	REV. B
PU	#	D3479	SHEET 3 OF 4
DATE		TITLE	SCALE
08.12.19		ADAPTER INLET	2:1



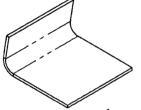


D3479-3F FLAT PATTERN

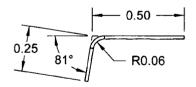
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)



D3479-3 99 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)



alo 64859





D3479-5 81 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

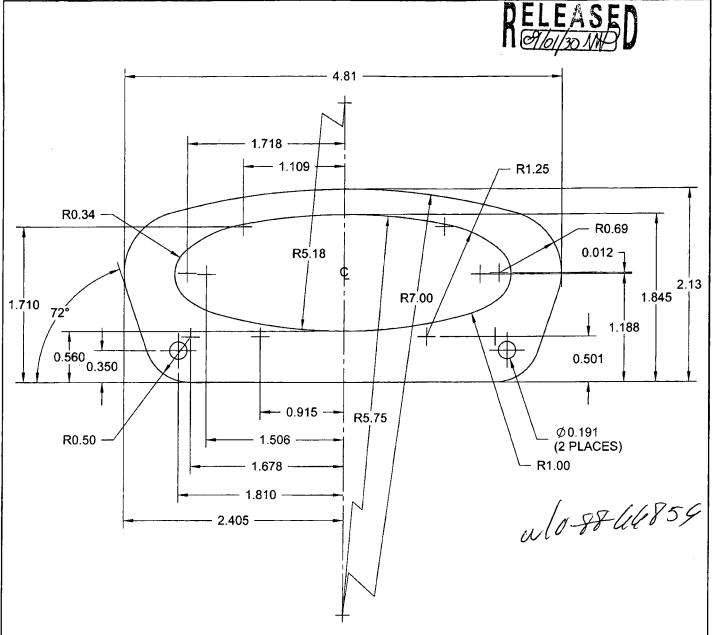
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Part No: PAR #:		Fault Cate	NCR: Yes No DQA:				Date:			
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	0750	Description of NC	Corrective Action Section			Verification		ation	Approval	Approval
DATE STEP		Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Sectio		Chief Eng	QC Inspector
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NOTE: D	oto 0 initi	al all entries								
NOTE: D	ate & miti	ai aii enines								

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D3479-7 FLANGE PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) PART IS SYMMETRICAL ABOUT CENTERLINE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:			WC	RK ORDER CHANG	iES						
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

		*									
Part No: PAR #:			Fault Category: NC Disposition: QA			CR: Yes No DQA: Date:					
Resolution:		IA: N/C Closed:				Date:					
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NO	R)					
DATE	STEP	Description of NC	Corrective Action Initial Action Descri		tion B	Sign & Verific			Approval		
- iji		Section A		Action Description Chief Eng			tion C		QC Inspector		
1	-	<u> </u>	Chief Eng	Chief Eng	Da	te		Chief Eng			
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NOTE: Date & initial all entries

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SPOT WELD TEST RECORD AMS-W-6858A

CLASS 'C'

TEST NO: 97	
EMPLOYEE: Marc Gregory	
PART NUMBER: 13474-041	JOB NUMBER: 46 8 5 6
MATERIAL TYPE: 304	MATERIAL THICKNESS:
GROUP SPECIFICATION:	Group 1: Aluminum & magnesium Group 2: Iron; nickel; cobalt Group 3: Titanium
TEST RESU	ULTS
PASS FAIL	
VISUAL:	
PENETRATION: [/] []	
PENETRATION: / PULL STRENGTH: [/] [] PSI I	Reading:
٠,	
The individual named above has been to standard AMS-W-6858A, and QSI 004	rained and is qualified in accordance with (ref: 4.3)
DATE OF TEST COUPON: ((03/14) QUALIFIER:	